

Ship Aug 3

Work Order ID 149305

Friday, July 22, 2016 10:43:02 AM

149305

stock Page 1

Item ID: D412-698-015 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Support - V Block
 Start Date: 7/22/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/2/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Em Date: 16/07/22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev <u>1</u>								
100	Document Control	DAS 6 9-89 0.00		III 28 2016				DAS 21 9-89	16-07-28 (4)
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-698-015 CHG001								
									JUL 28 2016
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
									JUL 28 2016
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.02							
Quality Control									
									JUL 28 2016

4 DAS
28
9-89

JUL 28 2016

4 DAS
6
9-89

JUL 28 2016

DAS
27
9-89

4 DAS
28
9-89

JUL 28 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 			
Description Work Order Deviation				Disposition							
								Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
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Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Revision ID:

Stop ***NS2***

Item Name: Door Support - V Block

Start Date: 7/22/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/2/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					DAS 27 9-89	DAS 28 9-89		
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-015 Location:FG022								
140	QC21- Final Inspection - Work Order Release	0.00							
140							DAS 21 9-89		
QC	Memo	0.07							
Quality Control									

JUL 28 2016

AUG 03 2016

dm 16/07/28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

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Page 1

Work Order ID: 149305

149305

Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support - V Block

Start Date: 7/22/2016

Required Date: 8/2/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing 06-01-25 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3200-1		Manufactured	No			110	Each	28.0000	2	8			
D3200-1									**				
Door Post Block													
DAS 28 9-89				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST022				3					
				143974				3		3			
				ST025A				25					
				146705				25		5			
D3200-3		Manufactured	No			110	Each	35.0000	2	8			
D3200-3									**				
Door Wedge													
DAS 28 9-89				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST023				35					
				142468				9		8			
				148288				26					
D3201-1		Manufactured	No			110	Each	2.0000	2	8			
D3201-1									**				
Doubler										148296 X6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST023				2					
				140936				2		2			
DAS 28 9-89													

DAS 6 27 9-89 9-89

DAS 6 27 9-89 9-89

DAS 6 27 9-89 9-89
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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support - V Block

Start Date: 7/22/2016

Required Date: 8/2/2016

Start Qty: 4.00

Required Qty: 4.00

D3201-3 Manufactured No

110 Each 17.0000 1 4

D3201-3

Angle

DAS
28
9-89

Location

Loc Qty

Loc Code

ST023

17

139596

5

140937

12

**

DAS
6 DAS
9-89 27
9-89

D3201-4 Manufactured No

110 Each 5.0000 1 4

D3201-4

Angle

DAS
28
9-89

Location

Loc Qty

Loc Code

ST023

5

139570

5

**

DAS
6 DAS
9-89 27
9-89

MS21042L3 Purchased No

110 Each 2,313.000 12 48

MS21042L3

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK007

600

m135056

600

FP001

14

m133790

14

GA

571

m134360

112

m135135

459

OVER007

700

m135135

700

ST303

428

m134039

12

m134943

416

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DAS
6 DAS
9-89 27
9-89

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Picklist Print

Friday, July 22, 2016 10:43:02 AM

Work Order ID: 149305

149305

Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support - V Block

Start Date: 7/22/2016

Required Date: 8/2/2016

Start Qty: 4.00

Required Qty: 4.00

MS24693-S277

Purchased

No

110

Each

56.0000

12

48

MS24693-S277

**

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST286

56

M134063

56

48

NAS1149D0332J

Purchased

No

110

Each

1,614.000

12

48

NAS1149D0332.J

**

Washer

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

546

m134848

546

GA

979

m135046

979

ST264

83

m134502

6

m134738

77

48

DAS
6
9-89 27
9-89

DAS
6
9-89 27
9-89

JUL 28 2016

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW